

Date: Tuesday, 02/10/2007 12:57:54 PM
User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	ARM
Job Number :	34966		
Estimate Number :	12883		
P.O. Number :	N/A	Part Number :	D3560043
This Issue :	02/10/2007	S.O. No. :	N/A
Prsht Rev. :	NC	Drawing Number :	D3560 UNDER REVIEW
First Issue :	N/A	Project Number :	N/A
Previous Run :	34476	Drawing Revision :	B
Written By :		Material :	N/A
Checked & Approved By :		Due Date :	09/10/2007
Comment :	Est Rev:A New Issue 07.05.24 EC	Qty:	5 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1
PULL FROM STK:

2.0	D3560043	ARM WELDMENT
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)
ARM WELDMENT 3×32646

3.0	D35921	PLATE
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)
PLATE $3 \times 32661 = 4$ $3 \times 34260 = 1$

4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1-Weld assembly as per dwg D3560

5.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

6.0	QC9	VISUAL WELDING INSPECTION
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Comment: VISUAL WELDING INSPECTION



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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 34966

Part Number: D3560043

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

A.M.

07.10.03

(5)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

R

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07.10.03

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *WA*

A.M.

07.10.03

(5)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

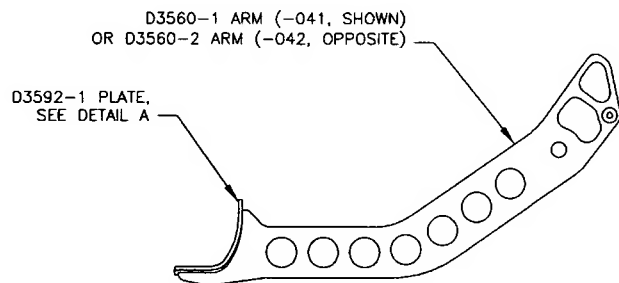
07.10.03

Job Completion

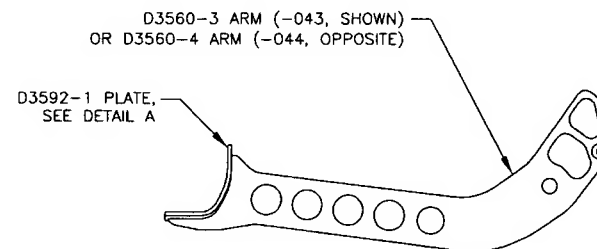


07.10.03

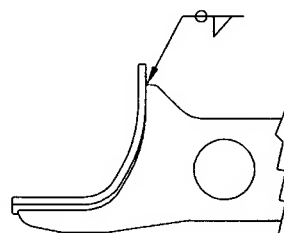
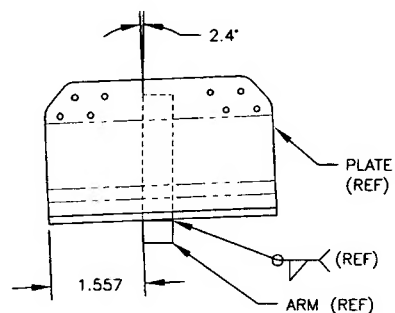




D3560-041 ARM WELDMENT (SHOWN),
D3560-042 ARM WELDMENT (OPPOSITE)



D3560-043 ARM WELDMENT (SHOWN),
D3560-044 ARM WELDMENT (OPPOSITE)



DETAIL A
(SCALE 1:1)

GENERAL NOTES

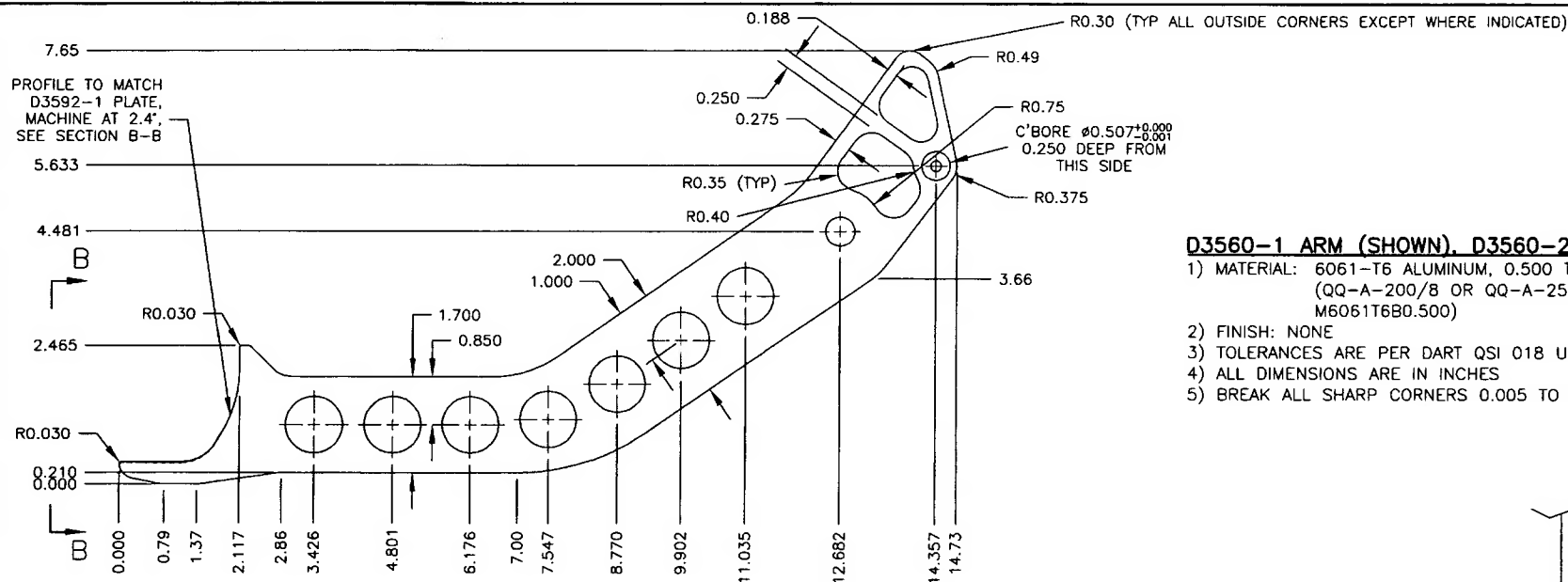
- 1) WELD PER QSI 004
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

RELEASED
07.06.19

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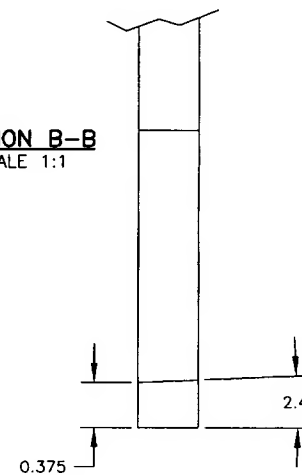
C	07.06.19	REMOVE POWDER COAT
B	07.01.15	REDESIGN AS WELDMENT, ADD POCKETS
A	06.09.25	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE LTD. HAMPSHIRE, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3560
DATE	07.06.19	TITLE ARM WELDMENT
		REV. C SHEET 1 OF 3 SCALE 1:4



D3560-1 ARM (SHOWN), D3560-2 ARM (OPPOSITE)

- 1) MATERIAL: 6061-T6 ALUMINUM, 0.500 THICK
(QQ-A-200/8 OR QQ-A-250/11, REF DART SPEC. M6061T6B0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP CORNERS 0.005 TO 0.015

SECTION B-B SCALE 1:1

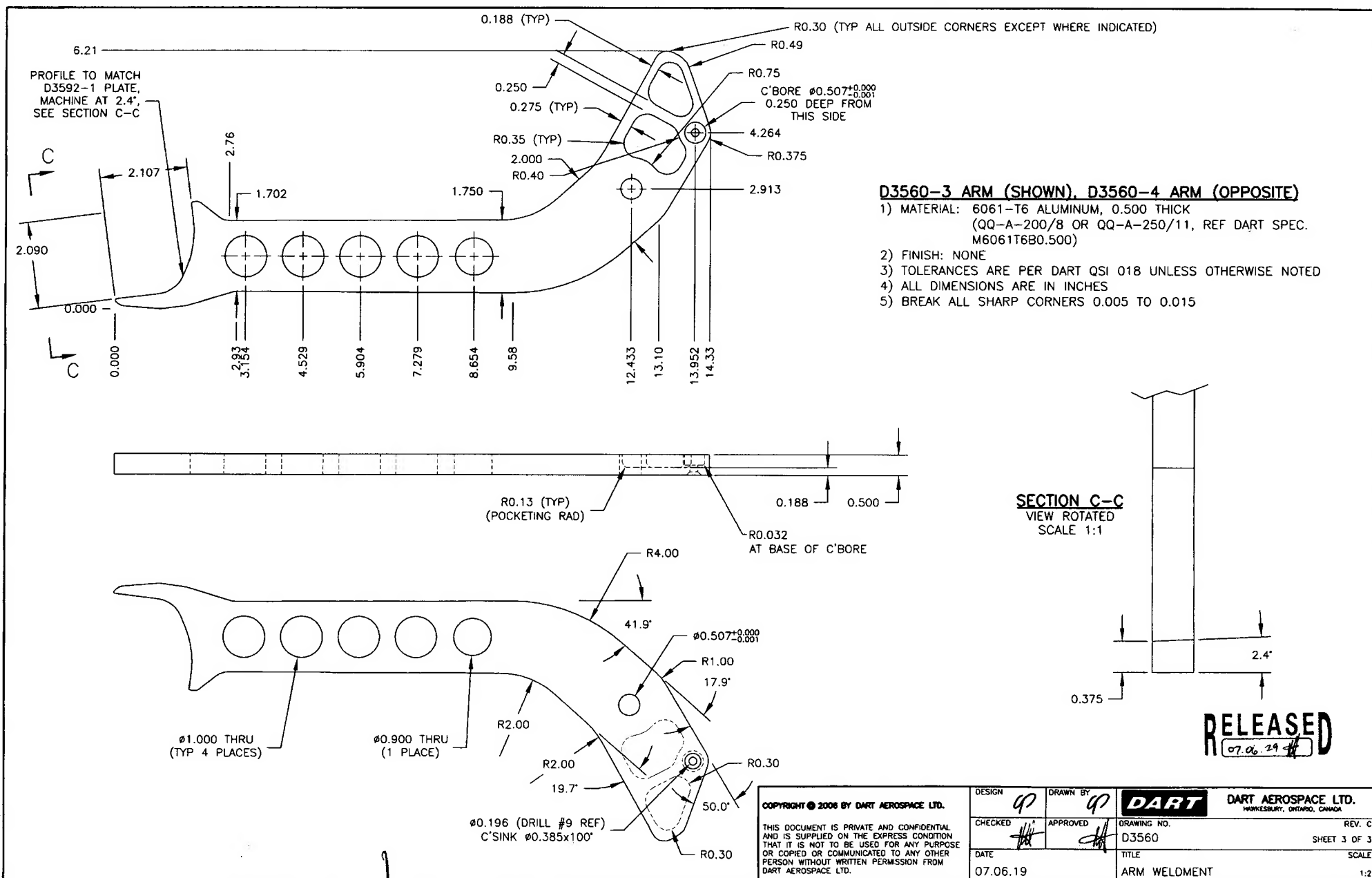


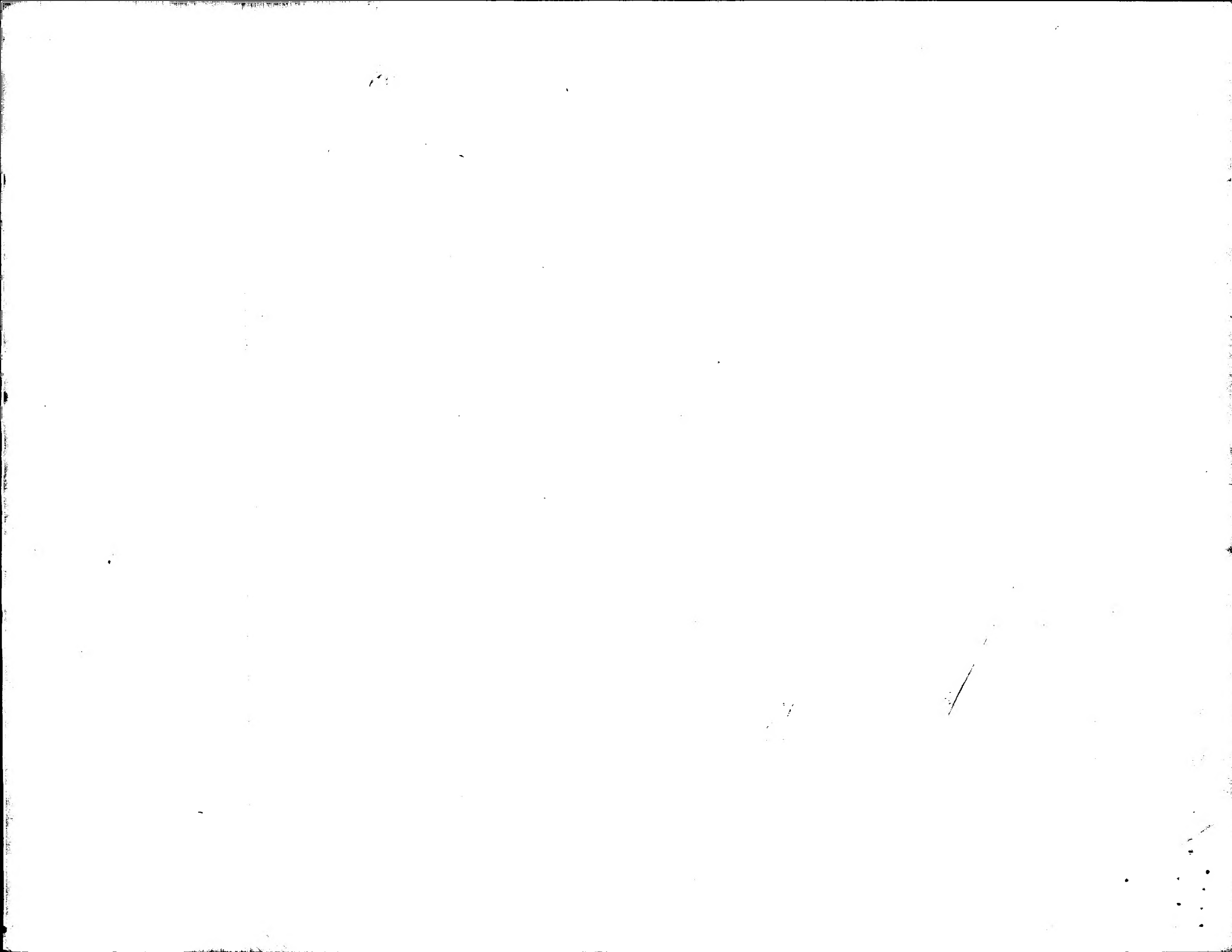
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DESIGN	qf	DRAWN BY	qf	DART	DART AEROSPACE LTD. MARKESBURY, ONTARIO, CANADA
CHECKED	df	APPROVED	df	DRAWING NO. D3560	REV. C SHEET 2 OF 3
DATE 07.06.19				TITLE ARM WELDMENT	SCALE 1:2





W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 07/10/03
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07.10.03	4.	Qty(1) ARM IS TOO NARROW AT WELD BECAUSE OF GRINDING DURING RE-WELD	UP 07.10.03 per QSI 042	SCRAP. AND Replne Replne D3560-43 B2 32644 D35621 B2 32644 A 121 032004	ph 07.10.03 ph 07.10.03 ph 07.10.03	En H10/03	UP 07.10.03 per QSI 042	En H10/03
			weld	Inspect head & q welding inspection	07.10.03	En H10/03	↓	En H10/03

NOTE: Date & initial all entries

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/10/04	to	(3) Scrap all the parts that were reviewed twice. (Arm D 32646) - Drum . and chairs	UP 07.10.04 per QSI 042	Scrap and Destroy. Replace with all new parts. weld per ASZ 004	pk 07.10.04	S 07/10/04	UP 07.10.04 per QSI 042	En 07/10/04
			UP 07.10.04 per QSI 142	Re. inspect weld AC 19 Re inspect AC 15	PD 07.10.04 En 07/10/04	S 07/10/04	UP 07.10.04 per QSI 042	En 07/10/04

NOTE: Date & initial all entries